

Date: Wednesday, 2/8/2006 7:06:44 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 25730		Part Number	: D314091	
Estimate Number	: 11465		Drawing Number	: D3140 REV D	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/8/2006 S.O. No. : N/A		Drawing Revision	: D	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 2/15/2006	
Previous Run	: N/A		Qty:	2 Um: Each	
Written By	<u>SPE COMMENT Below</u>				
Checked & Approved By	<u>ML</u>				
Comment	: Est. A02.04.30 New Issue NG				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
		Comment: Qty.: 0.1549 sf(s)/Unit Total : 0.3098 sf(s) 2024-T3 .032 sheet Matl: 2024-T3 (QQ-A-250/4) .032" thick (M2024T3S.032) 5.00" x 4.06" flat pattern ref Note grain direction Batch <u>M12758</u> ml 06/02/08 2
2.0	SHEAR	SHEAR
		Comment: SHEAR Cut as per dwg D3140 ml 06/02/08 2
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Deburr. No sharp edges Notch out .75 x .40 corner as per dwg (-91 shown) Form as per dwg (-91 shown) ml 06/02/08 2
4.0	QC5	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP ml 06/02/13 2
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 ml 06/02/15 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 206102/20 (2)

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C 206102/20 (2)

8.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21 595 06/02/21 (2) 06/02/21 (2)

Job Completion

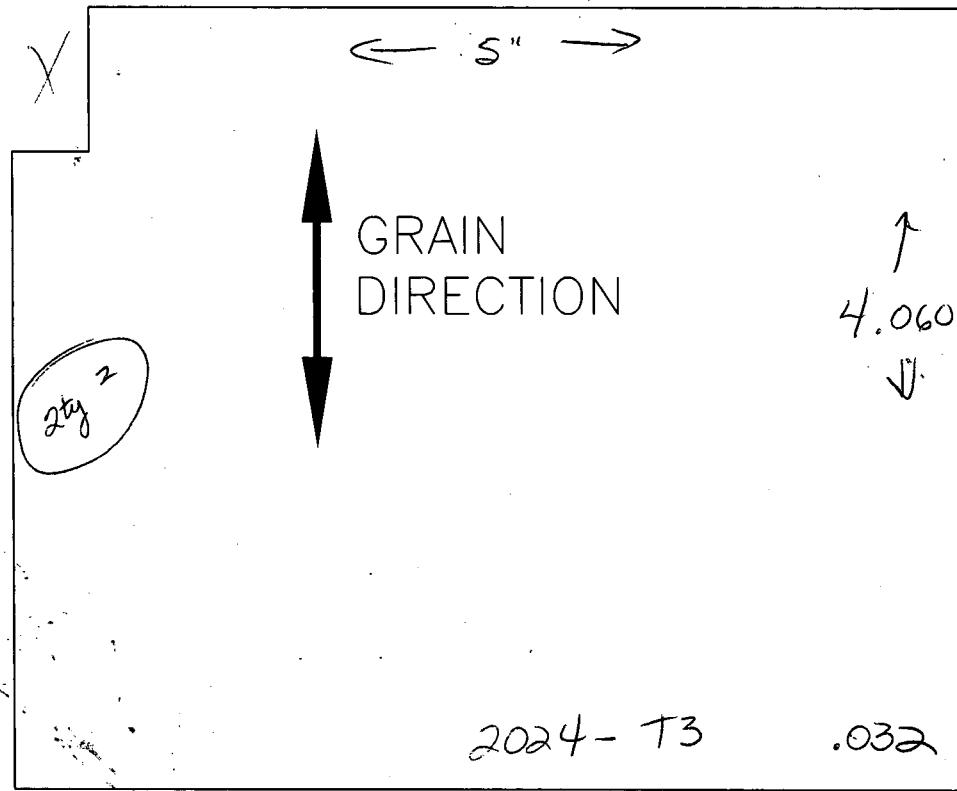


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3140-91F FLAT PATTERN
(USE TO MAKE D3140-91/-92 DOUBLERS)

REFERENCE ONLY

**GRAIN
DIRECTION**

